

Date: Thursday, 01/05/2008 9:46:02 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	END PLATE
Job Number :	38926		
Estimate Number :	10547		
P.O. Number :		Part Number :	D30671
This Issue :	01/05/2008	Drawing Number :	D3067 REV A
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	A
Previous Run :	37571	Material :	
Written By :		Due Date :	07/05/2008
Checked & Approved By :	JUO 08.5.01	Qty:	160
Comment :	Est:03.01.21 Remove step 6 (Deburr) KJ Est Rev:B Now on Water jet 06-06-16 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S063	5052-H32 .063 Sheet
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IS



Comment: Qty.: 0.0656 sf(s)/Unit Total: 10.5000 sf(s)

5052-H32 .063 Sheet

Material: 5052-H32 (QQ-A-250/8)

M5052H32S.063) or 6061-T6 (QQ-A-250/11) (Ref. M6061T6S.063)

Batch:

107276 IB 8-5-6

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3067

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

IB 8-5-6

225

08/05/06 225 dm

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-5-6

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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2SP019

**Comment:** SECOND CHECK

08/05/06

225

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

Bend as per Dwg D3067

08/05/07

225

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 01/05/2008 9:46:03 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END PLATE

Job Number: 38926

Part Number: D30671

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO NEXT STEP

QSP019

02/05/2008 x225

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA*

03-05-20 225

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/2008

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

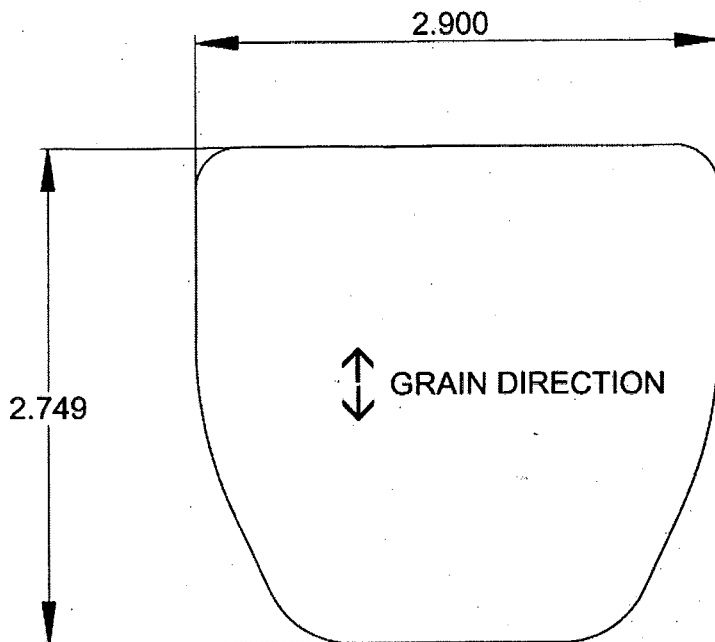
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

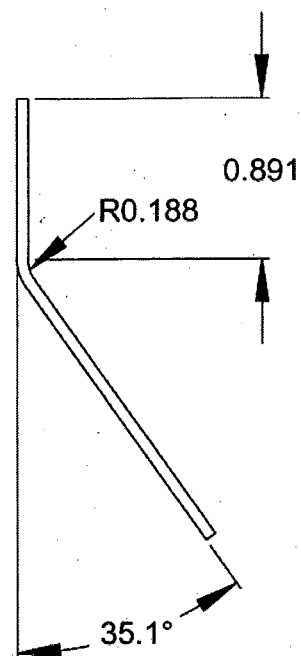


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. D3067	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE END PLATE	SCALE 1:1
A	02.09.11	NEW ISSUE	

RELEASED
02.09.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38926

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRJT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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